

Next please

Dart Aerospace Ltd.

Date: Wednesday, 5/31/2006 7:40:02 AM
User: Kim Johnston

Process Sheet

Split 26.07.11 26

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 27307-1
Estimate Number : 10460
P.O. Number : NIA
This Issue : 5/31/2006 S.O. No. : NIA
Prsht Rev. : NC
First Issue : NA Type : LARGE FAB ASSY
Previous Run : 27045
Written By : SEE COMMENT BELOW
Checked & Approved By : 06.05.31
Comment : Est Rev: H 04.11.09 Reformat KJ/JLM

Drawing Name : 350 STEP ASSEMBLY, SHORT HIGH SKID
Part Number : D350591113
Drawing Number : D2310 REV D
Project Number : N/A
Drawing Revision : D
Material : NIA
Due Date : 6/30/2006 Qty: 6 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP D350-591-113 CHG003

2.0 D2244116 Step Extrusion



Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

Pick:

Qty Part number Description Batch

1 D2244 Step Extrusion 223404

PE 06.06.26

3.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2244 extrusion to 62.00" long as per Dwg D2310

2-Drill extrusion as per Dwg D2310 using drill Jig DT8230

3-Deburr

PE 06.06.26
PE 06.06.26
PE 06.06.26

4.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5.0 D267334 End Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick:

Qty Part number Description Batch

PE 06.06.26

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Mfg / Design Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Design Mgr | Approval QC Inspector |
| | | | Initial Design-Mgr | Action Description Design Mgr | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Wednesday, 5/31/2006 7:40:02 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 STEP ASSEMBLY, SHORT HIGH SKID

Job Number: 27307

Part Number: D350591113

Job Number:



Seq. #:

Machine Or Operation:

Description :

2 D2673-34

End Cap

325396

6.0

D2275

Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

Pick:

Qty Part number

Description Batch

1 D2275

Bushing

317557

7.0

D2582

Hi-Skid Step Leg Ass'y



Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

Pick:

Qty Part number

Description

Batch

1 D2582

Step Leg Assembly

325395-4

825089-622

8.0

MS20600AD4W3

Cherry Rivets



Comment: Qty.: 16.0000 Each(s)/Unit Total: 96.0000 Each(s)

Pick:

Qty Part number

Description

Batch

16 MS20600AD4W3

Rivet

M101415=30

M13767=66

9.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld Fwd end cap and bushing as per Dwg D2310

A/R

AL ROD

Batch:

M19173

M15689

2-Grind end cap and bottom bushing welds flush

3-Machine top weld on bushing flush

10.0

QC5/9

WELD INSPECTION



Comment: WELD/WORK INSPECTION

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Mfg / Design Mgr | Approval QC Inspector |
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| | | | | | | | |

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Design Mgr | Approval QC Inspector |
| | | | Initial Design Mgr | Action Description Design Mgr | Sign & Date | | | |
| | | | | | | | | |
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| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 STEP ASSEMBLY, SHORT HIGH SKID

Job Number: 27307

Part Number: D350591113

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SAD 06.06.17

12.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Rivet as per Dwg D2310

2-Inspect for foreign object as per QSI 024

3-Weld Aft end cap as per Dwg D2310

A/R AL ROD Batch: M100660

4-Grind end cap welds flush

LE. 06.06.28 6

LE. 06.06.28 6

LE. 06.06.28 6

FF 06.06.29 6

13.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

M06/06/29 / 06.06.29 6

14.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Touch up Alodine

FF 06.06.29 6

15.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

a.m 06-07-08

16.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D2310 and QSI 005 4.4

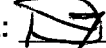
Batch: M101266

a.m 06-07-10

6

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Mfg / Design Mgr | Approval QC Inspector |
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| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Design Mgr | Approval QC Inspector |
| | | | Initial Design Mgr | Action Description Design Mgr | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA:  Date: 06/07/14

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Wednesday, 5/31/2006 7:40:02 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 STEP ASSEMBLY, SHORT HIGH SKID

Job Number: 27307

Part Number: D350591113

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION AND WING WALK

AB 06/07/11 (5)

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Pick Packing Kit

19.0

K591113

Short Step Instn Kit



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick Packing Kit:

Qty Part number

Description Batch

1 K591-113

Hardware Kit

B27308

AB 06/07/10 (6)

20.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

AB 06/07/10 (6)

21.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-591-113

Location: *Rev. H.*

AB 06/07/11 (5)

22.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

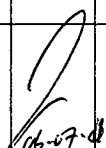
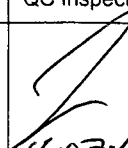
Inspection Level 21

AB 06/07/11 (5)

Job Completion



W 06-07-11

| W/O: | | WORK ORDER CHANGES | | | | | |
|----------|------|---------------------------|---|------|-----|---------------------------------|---|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Mfg / Design Mgr | Approval QC Inspector |
| 06-07-11 | 17 | W/O split here. 5 remain. |  06-07-11 | | 5 | |  06-07-11 |
| | | | | | | | |

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Design Mgr | Approval QC Inspector |
| | | | Initial Design Mgr | Action Description Design Mgr | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART

| | | | |
|------------------------|-------------------------|--|------------------------|
| DESIGN KE | DRAWN BY PH | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED [Signature] | APPROVED [Signature] | DRAWING NO. D2310 | REV. 0 SHEET 1 OF 2 |
| DATE 05.11.14 | | TITLE HIGH SHORT STEP ASSEMBLY | SCALE NTS |
| A | 94.11.10 | NEW ISSUE | |
| B | 97.05.22 | END CAPS CHANGED | |
| C | 97.07.23 | ADDED BUSHING AND FACING INFO | |
| D | 05.11.14 | UPDATE FINISHING NOTE | |

D2310 HIGH SHORT STEP ASSEMBLY PARTS LIST

| Part No. | Description | QTY |
|--------------|--------------------------|-----|
| D2310 | High Short Step Assembly | X |
| D2244-62.0 | STEP EXTRUSION* | 1 |
| D2275 | BUSHING | 1 |
| D2582 | STEP LEG ASSEMBLY | 1 |
| D2673-34 | STEP END PLATE | 2 |
| MS20600AD4W3 | Rivets | 16 |

*cut per drawing

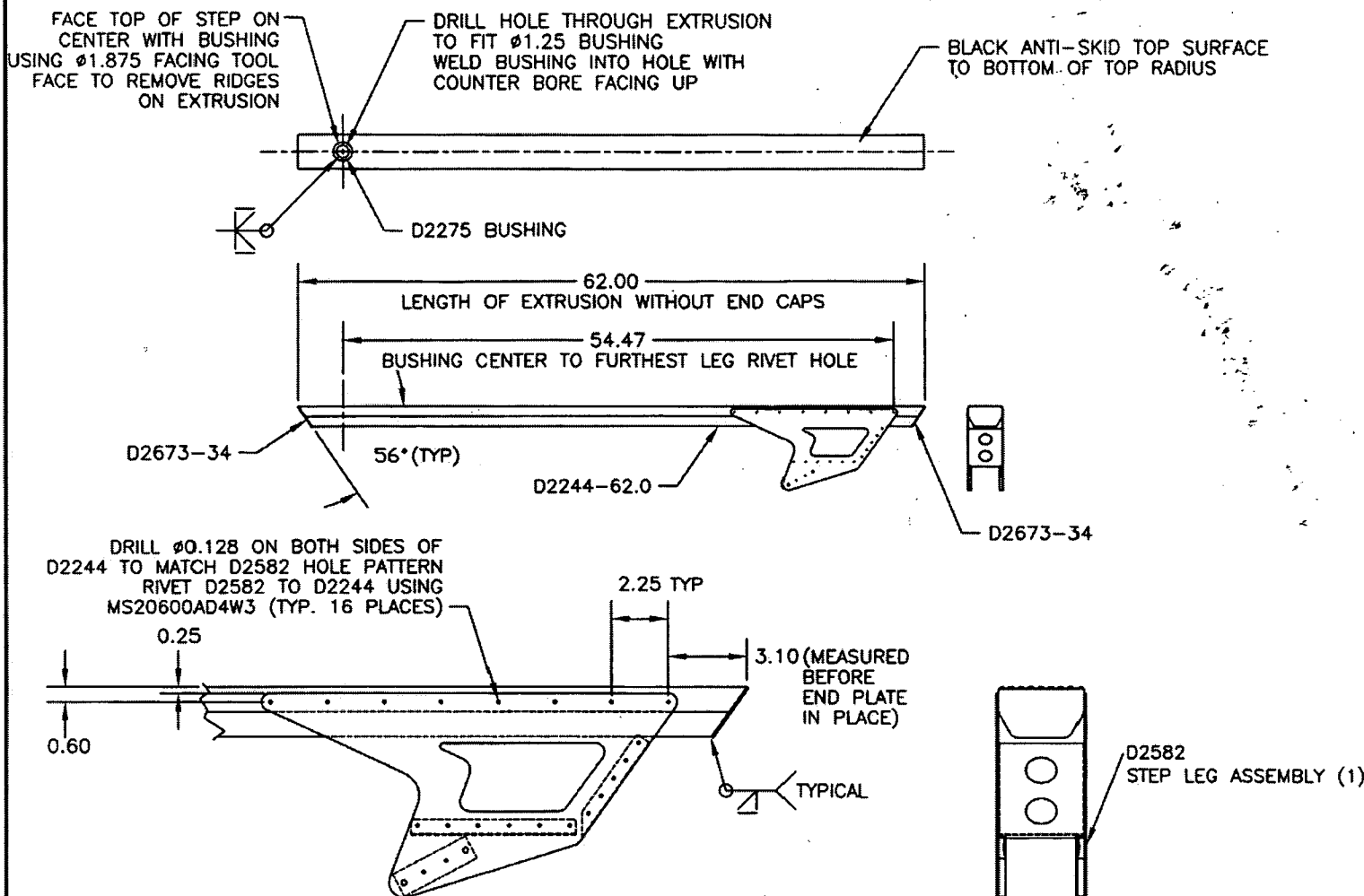
SHOP COPY
RETURN TO
ENGINEERING
RELEASED
CONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 27307

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DART

| | | | | |
|---------|--------------------|-------------|--------------------------|-----------------------------|
| DESIGN | KE | DRAWN BY | PH | DART AEROSPACE LTD |
| CHECKED | <i>[Signature]</i> | APPROVED | <i>[Signature]</i> | HAWKESBURY, ONTARIO, CANADA |
| DATE | 05.11.14 | DRAWING NO. | D2310 | REV. D |
| | | TITLE | HIGH SHORT STEP ASSEMBLY | SHEET 2 OF 2 |
| | | | | SCALE |
| | | | | NTS |



STEP LEG DETAIL

D2310 HIGH SHORT STEP ASSEMBLY

- 1) MAKE FROM D2244 STEP EXTRUSION
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
FOR INFORMATION
ONLY
NO. 27307

WORK ORDER
WITHOUT NOTICE

Date: Wednesday, 5/31/2006 7:40:02 AM
 User: Kim Johnston

Process Sheet

26

| | | | |
|------------------------------------|-------------------------------------|---------------------------|------------------------------------|
| Customer : | CU-DAR001 Dart Helicopters Services | Drawing Name : | 350 STEP ASSEMBLY, SHORT HIGH SKID |
| Job Number : | 27307 | | |
| Estimate Number : | 10460 | | |
| P.O. Number : | | Part Number : | D350591113 |
| This Issue : | 5/31/2006 | Drawing Number : | D2310 REV D |
| Prsht Rev. : | NC | Project Number : | N/A |
| First Issue : | 1/1 | Drawing Revision : | D |
| Previous Run : | 27045 | Material : | |
| Written By : | | Due Date : | 6/30/2006 |
| Checked & Approved By : | | Qty: | 6 |
| Comment : | Est Rev: H 04.11.09 Reformat KJ/JLM | Um: | Each |

Additional Product

Job Number:



| | | |
|----------------|------------------------------|----------------------|
| Seq. #: | Machine Or Operation: | Description : |
|----------------|------------------------------|----------------------|

| | | |
|-----|----|------------------|
| 1.0 | DC | DOCUMENT CONTROL |
|-----|----|------------------|



Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP D350-591-113 CHG003

06.06.19

| | | |
|-----|----------|----------------|
| 2.0 | D2244116 | Step Extrusion |
|-----|----------|----------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

Pick:

Qty Part number Description Batch

1 D2244 Step Extrusion

| | | |
|-----|-------------|------------------------------|
| 3.0 | LARGE FAB 1 | LARGE FABRICATION RESOURCE 1 |
|-----|-------------|------------------------------|



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2244 extrusion to 62.00" long as per Dwg D2310

2-Drill extrusion as per Dwg D2310 using drill Jig DT8230

3-Deburr

| | | |
|-----|-----|------------------------------|
| 4.0 | QC5 | INSPECT WORK TO CURRENT STEP |
|-----|-----|------------------------------|



Comment: INSPECT WORK TO CURRENT STEP

| | | |
|-----|---------|-----------|
| 5.0 | D267334 | End Plate |
|-----|---------|-----------|



Comment: Qty.: 2.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick:

Qty Part number Description Batch

REFERENCE ONLY